

Work Order ID 146831

Tuesday, May 24, 2016 9:56:00 AM

146831

Page 1

Item ID: D5273-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Fitting Assembly

Start Date: 5/5/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5273	B

100

Cut blanks as per folio

0.08

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 4.70"

DAS

14

9-89

16/06/16

110

1.00

110

HAAS 5AXIS

Memo

0.00

HAAS CNC vertical machine #5

MACHINE AS PER DWG & FOLIO FB403/ D5273-3

FOLIO REV: AADWG REV: B

DO NOT BUFF OR POLISH PART

DEBURR

DAS

08

9-89

B. 16/06/19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By 36 JUN 20 2016	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: <i>Work Order step 140 NO Qc5</i>							
Misidentified ☐	Past Due ☐								

Work Order ID 146831

Tuesday, May 24, 2016 9:56:00 AM

146831

Page 2

Item ID: D5273-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End Fitting Assembly

Start Date: 5/5/2016 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC2- Inspect parts off machine FAI/FAIB

0.02

120

QC

Memo

0.00

Quality Control

B.A 16/06/19

4

Ø

DAS
08
9-89

130 QC8- Inspect parts - second check

0.02

130

QC

Memo

0.00

Quality Control

4

Ø

DAS
49
9-89

16/06/20

140 QC5- Inspect part completeness to step on W/O

0.02

140

QC

Memo

0.00

Quality Control

N/A PD 16-07-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : _____							

Work Order ID 146831

Tuesday, May 24, 2016 9:56:00 AM

146831

Page 3

Item ID: D5273-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Fitting Assembly

Start Date: 5/5/2016 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Outsource process-Anodize per QSI017 4.1.10.1	72.00							
150									
Outsource4	Memo	0.00							
Outsource process - Anodize	ISSUE P/O TO ATG: <u>32760</u>								
	ANODIZE BLACK AS PER DWG AND MIL SPEC								
	C OF C IS REQUIRED								
160	Receive & Inspect for Damage & Mat'l Certs	0.02							
160									
Packaging	Memo	0.00							
Packaging	C OF C IS REQUIRED								
170	QC5- Inspect part completeness to step on W/O	0.02							
170									
QC	Memo	0.00							
Quality Control									

4 JUN 20 2016 13 9-89

41 8016-7-11

(4) DAS 38 9-89 JUL 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 146831

Tuesday, May 24, 2016 9:56:00 AM

146831

Page 4

Item ID: D5273-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Fitting Assembly

Start Date: 5/5/2016 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.25							
180									
Small Fab	Memo	0.00							
Small Fab	INSTALL ANCHOR NUT AS PER DWG								
190	QC5- Inspect part completeness to step on W/O	0.02							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: St227A	0.02							
200									
Packaging	Memo	0.00							
Packaging									

DAS
36
9-89
16/07/13

④

DAS
38
9-89

JUL 13 2016

4
DAS
6
9-89

JUL 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 146831

Tuesday, May 24, 2016 9:56:00 AM

146831

Page 5

Item ID: D5273-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Fitting Assembly

Start Date: 5/5/2016 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.10							
210									
QC	Memo	0.00							
Quality Control									

DAS

21

9-89

JUL 14 2016

DAS

21

9-89

JUL 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, May 24, 2016 9:55:59 AM

Page 1

Work Order ID: 146831

146831

Parent Item: D5273-043

D5273-043

Parent Item Name: End Fitting Assembly

Start Date: 5/5/2016

Required Date: 5/24/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.07.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CR3212-4-5		Purchased	No				Each	358.0000		40			DAS
CR3212-4-5									**			16/07/13	36 9-89
Cherry Rivet													
* CR1122-3-02.5													
				OS1042									
				16.07.13									
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				CCK005				100					
				m134654				100					
				ST320				258					
				m134537				100					
				m134574				158					
M6061T6B2.750X03.75		Purchased	No				f	9.8000		1.684211			
0													
M6061T6B2 750X03 750									**				
6061-T6 BAR 2.75 X 3.75													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				MAT005				9.8					
				m134158				9.8					
MS21076-3		Purchased	No				Each	208.0000		20			DAS
MS21076-3									**				36 9-89
Anchor Nut													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST298				208					
				m132883				38					
				m134502				50					
				m134612				120					
										20			

M134612
40x

16/10/16

16/07/13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042).Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

DART AEROSPACE LTD		Work Order:	14683
Description: End Fitting		Part Number:	D5273-3
Inspection Dwg: D5273	Rev: B	Page 1 of 1	

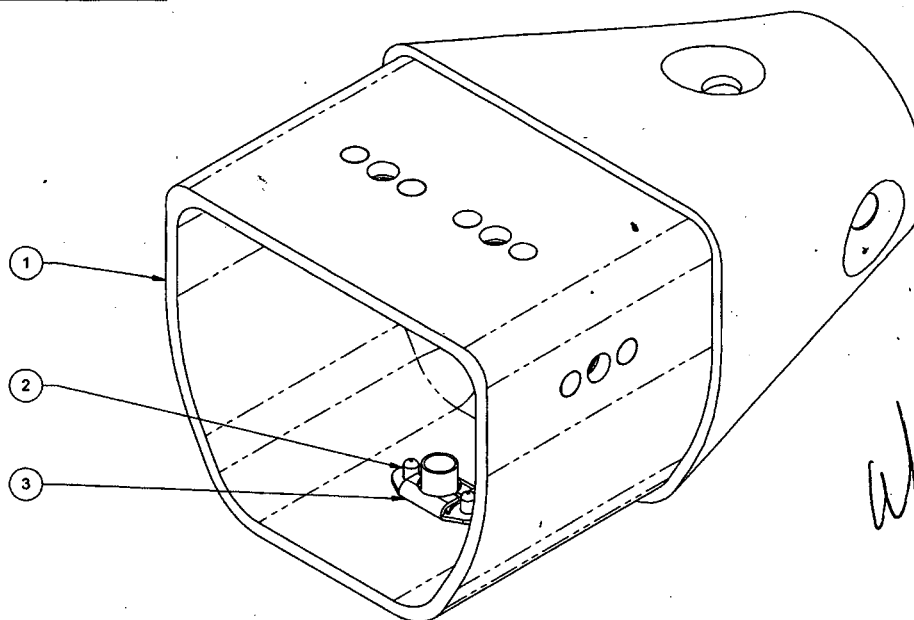
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.004	✓		Vern	GA-13
4.50	+/-0.030	4.510	✓		H-6	31006
2.140	+/-0.010	2.140	✓		Vern	GA-13
0.100	+/-0.010	0.099	✓		Mic	118-120
CSK 100°	+/-0.5°	100°	✓		Angle M	CNC-17
R0.25	+/-0.030	R0.250	✓		R-6	ref.
1.287	+/-0.010	1.289	✓		Vern	GA-13
0.06	+/-0.030	0.060	✓		"	"
2.500	+/-0.010	2.496	✓		"	"
2.25	+/-0.030	2.252	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
2.00	+/-0.030	2.003	✓		Vern	GA-13
0.544	+/-0.010	0.540	✓		H-6	31006
0.925	+/-0.010	0.926	✓		"	"
0.500	+/-0.005	0.500	✓		Vern	GA-13
0.250	+/-0.005	0.250	✓		"	"
1.420	+/-0.010	1.420	✓		H-6	31006
3.00	+/-0.030	2.997	✓		Vern	GA-13
Ø1.510	+0.002/-0.000	Ø1.5102	✓		Mic/T-6	GA-02/ref.
Ø0.098	+0.004/-0.001	Ø0.098	✓		Vern	GA-13
Ø0.179 x 100°	+0.005/-0.001 x +/-0.5°	Ø0.181 x 100°	✓		"	"
Ø0.250	+0.005/-0.001	Ø0.255	✓		"	"
0.500	+/-0.010	0.503	✓		H-6	31006
1.000	+/-0.010	0.999	✓		"	"
Ø0.201	+0.005/-0.001	Ø0.201	✓		Vern	GA-13
2.340	+0.000/-0.010	2.339	✓		Mic	GA-04
10°	+/-0.5°	10°	✓		Angle M	CNC-12
2.840	+0.000/-0.010	2.839	✓		Mic	GA-04
R0.21	+/-0.030	R0.210	✓		R-6	ref.
R0.25	+/-0.030	R0.250	✓		"	"
0.080	+/-0.010	0.080	✓		Vern	GA-13
R0.51	+/-0.030	R0.510	✓		R-6	ref.
R2.01	+/-0.030	R2.010	✓		"	"
0.10	+/-0.030	0.100	✓		Mic	118-120

Measured by: <i>DA</i>	DAS	Checked by: <i>49</i>	QC Inspector:
Date: 16/06/19	08	Date: 16/06/20	Date:
Engineering Approval: (If necessary)		Date:	

Rev	Date	Change	Revised by	Approved
A	16.03.17	New Issue	KJ	

ITEM	QTY. -043	P/N	DESCRIPTION
	X	D5273-043	END FITTING ASSEMBLY
1	1	D5273-3	END FITTING
2	10	CR3212-4-5	RIVET, CSK
3	5	MS21076-3	ANCHOR NUT



D5273-043 END FITTING ASSEMBLY

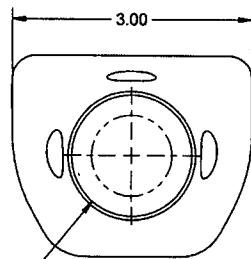
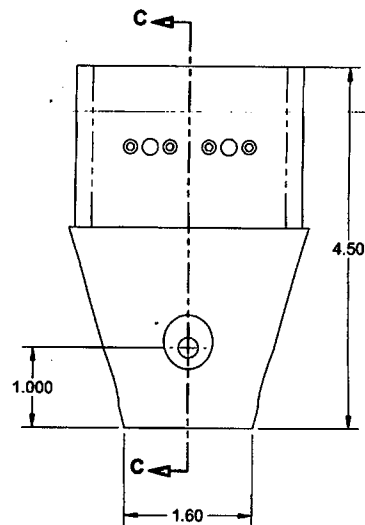
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5273-043" PER DART QSI 044 SECTION 6.1
- 7) WEIGHT: 0.81 lbs

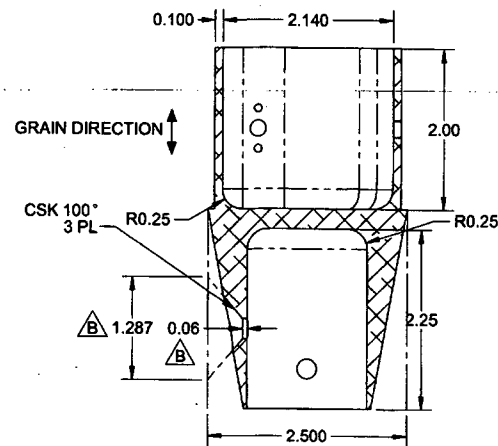
RELEASED
2016-03-07

APPROVED

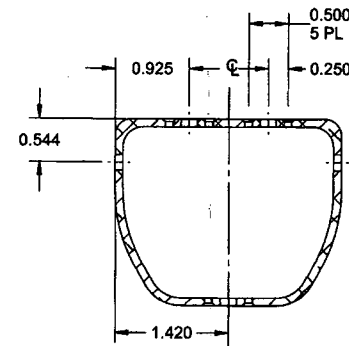
DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5273	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END FITTING	NTS
DATE	15.12.09	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	



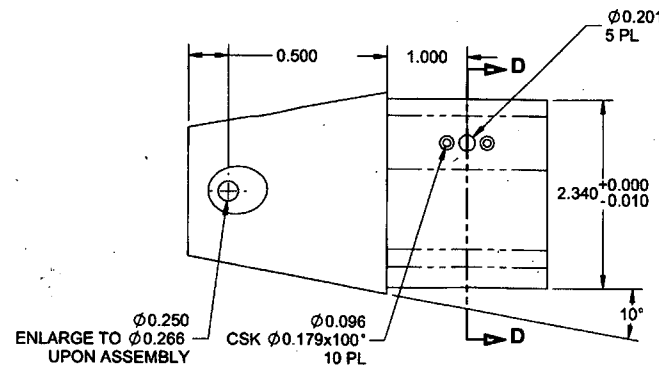
$\phi 1.510^{+0.002}_{-0.000}$



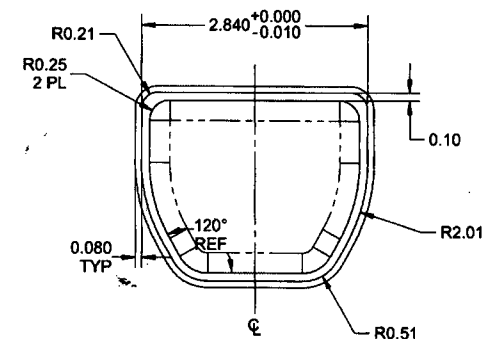
SECTION C-C



SECTION D-D



D5273-3 END FITTING



- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINIUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER MACHINING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.81 lbs
 - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DART DRAWING FILE "D5273-3REV B.SLDPRT"

RELEASED
2016-03-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC	
DRAWN	CC	EUGENE, OREGON, USA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5273	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END FITTING	NTS
DATE	15.12.09	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO32760

Purchase Order Date 6/20/2016

PO Print Date 6/27/2016

Page Number 4 of 7

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name
Vendor Phone 613-446-4544
Vendor Fax 613-446-4556
Ship To Contact
Ship To Phone

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Ship Method VENDOR'S TRUCK
Ship Acct

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
11	146966	D4726-1 HANDLE REV. A BLACK ANODIZE PER MIL-8625F TYPE III CLASS 2	6/30/2016 Yes 6/30/2016	10.00	\$27.00
Line Total:					\$27.00
14	146831 ✓	D5273-043 END FITTING ✓ REV. B	7/8/2016 Yes 7/8/2016	4.00 ✓	\$20.40
Line Total:					\$20.40

6/27/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911938

Date: 08-Jul-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
6 ea	Part: 145628 D5271-1 Forward fitting Job: 19708	PO: 32760	Rev: Line: 10
4 ea	Part: 146831 ✓ D5273-043 End fitting Job: 19710	PO: 32760	Rev: B Line: 14 <i>Sp/b = 74</i>
8 ea	Part: 147746 D5273-3-041 End fitting Job: 19711	PO: 32760	Rev: B Line: 15
1 ea	Part: 71401-45 Administration fee Job: 19713	PO: 32760	Rev: N/A Line: 18
16 ea	Part: 141006 646.3012 Lower Guide Job: 19700	PO: 32760	Rev: N/C Line: 5
6 ea	Part: 146954 D5230-3 Mounting plate Job: 19706	PO: 32760	Rev: A Line: 8
7 ea	Part: 145628 D5271-3 AFT fitting Job: 19707	PO: 32760	Rev: A Line: 9
DATE: <u>8/7/16</u>		CERTIFIED SIGNATURE: <u><i>[Signature]</i></u>	



A.T.G. INDUSTRIES INC.
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Ph: 613 632-9577

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Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

Quantity

Description

RECEIVER SIGNATURE: SP/16-7-11

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.

MADE IN CANADA.